

Work Order ID 141797

141797

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Thursday, February 11, 2016 1:56:01 PM

Item ID: D117-1006-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: BK117 Bubble Window RH
 Start Date: 2/11/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/18/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: FEB 11 2016 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-1006	B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-1006-012	CHG 002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ

SMB
10/4/15

DAS
28
9-89

MAR 29 2016

SMB
10/4/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification _____					
				QC / QA Coordinator Approval _____					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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141797

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: BK117 Bubble Window RH

Start Date: 2/11/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/18/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D117-1006-012 Location : FG106								
		Sold							
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SMB
16/4/5MLJ
APR 05 2016GHA
20160405

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 141797

141797

Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 14/03/24 DL
14.06.25 AS PER IIN REV.B DD VERF:JLM
AS PER chg003 DD VERF:JLM
IPP REV:B
IPP REV:C 14.12.18

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
LN9139M4X12		Purchased		No			Each	96.0000		2			
I N9139M4X12									**			DAS 8 9-89	DAS 28 9-89
SCREW													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST554			96					
					m129319			96		2			
D3802-1-180		Manufactured		No		110	Each	0.0000	1	1			
D3802-1-180									**	141803		DAS 8 9-89	DAS 28 9-89
Window Seal - 180"													
D3932-1		Manufactured		No		110	Each	6.0000	2	2			
D3932-1									**			DAS 8 9-89	DAS 28 9-89
Snap Vent													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST060			6					
					55837			4		2			
					88149			2					
D5034-2		Manufactured		No		110	Each	0.0000	1	1			
D5034-2									**	141802		DAS 8 9-89	DAS 28 9-89
Bubble Window													
D5093-041		Manufactured		No		110	Each	1.0000	1	1			
D5093-041									**				
Door Bracket Assembly													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST150			1					
					121331			1		1			

APR 01 2016

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Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

D5094-041

Manufactured No

110 Each

2.0000

1 1

D5094-041

Post Bracket Assembly

**

DAS

6

DAS

9-89

28

9-89

DAS

27

9-89

D5107-1

Manufactured No

110 Each

10.0000

1 1

D5107-1

Placard

**

DAS

6

DAS

9-89

28

9-89

DAS

27

9-89

D5115-1

Manufactured No

110 Each

8.0000

1 1

D5115-1

Door Prop

**

DAS

6

DAS

9-89

28

9-89

DAS

27

9-89

AN3-7A

Purchased No

110 Each

217.0000

45 45

AN3-7A

Bolt

**

DAS

6

DAS

9-89

28

9-89

Location

Loc Qty

Loc Code

over003

150

M129507

50

m133694

100

ST349

67

m132763

46

m132803

21

DAS

27

9-89

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Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 2/11/2016

Required Date: 2/18/2016

Start Qty: 1.00

Required Qty: 1.00

LN9355-6X40

Purchased

No

110

Each

42.0000

2

2

DAS

DAS

I N9355-6X40

BOLT

**

6

28

9-89

9-89

BAS
27
9-89

Location

Loc Qty

Loc Code

ST554

42

m129319

42

NAS1149D0363J

Purchased

No

110

Each

1,581.000

90

90

NAS1149D0363J

Washer

**

DAS

DAS

6

28

9-89

9-89

Location

Loc Qty

Loc Code

GA

64

m130799

64

ST260a

1000

m134055

1000

ST263

517

m133790

19

m133932

498

MS21042L3

Purchased

No

110

Each

2,161.000

45

45

MS21042L3

Nut

**

DAS

DAS

6

28

9-89

9-89

Location

Loc Qty

Loc Code

FP001

163

m133790

163

GA

162

m133790

162

ST304

1836

m134039

1836

BAS
27
9-89

APR 01 2016

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4.0 WEIGHT AND BALANCE

The following is the weight of the D117-1006-012 Bubble Window kit. It is the responsibility of the installer to account for the weight and balance of all removed parts.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-1006-012 Bubble Window Kit	6.89 lb 2.1 kg	44.8 in 1.1 m	308 in-lb 2.3 m-kg	112.9 in 2.9 m	778 in-lb 6.1 m-kg

5.0 PARTS LIST

Qty -012	Part Number	Description
X	D117-1006-012	BUBBLE WINDOW KIT
1	D3802-1-180	SEAL
2	D3932-1	SNAP VENT
1	D5034-2	BUBBLE WINDOW
1	D5093-041	DOOR BRACKET ASSY
1	D5094-041	POST BRACKET ASSY
1	D5107-1	PLACARD
1	D5115-1	DOOR PROP
45	AN3-7A	BOLT
2	LN9139-0412	SCREW
2	LN9355 6X40	BOLT
90	NAS1149D0363J	WASHER (AN960JD10)
45	MS21042L3	NUT
1	27465A315	DRILL BIT FOR PLASTICS